

# Work Order ID 52228

Monday, September 21, 2009 11:41:36 AM



Page 1

Item ID:	D3315-2	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Wearplate					
Start Date:	9/21/2009	Start Qty:	4.00	Cust Item ID:		
Required Date:	10/2/2009	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>B/MS</u>	Date:	<u>09-9-21</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3315	Rev B								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg D if necessary								
	<input type="checkbox"/> Dwg Rev: <u>B</u>								
	<input type="checkbox"/> Prog Rev: <u>B</u>								
	<input type="checkbox"/> 2-Deburr								
									(6)
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

MAI NOT PULLED

13 9-9-25

13 9-9-25

27 5 02/02/25

(46)

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**Accept**

[illegible]**Setup Start**

**Stop**

[illegible]**Cust Item ID:**

**Customer:**

**Reference:**

Run Start

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Stop**

**Insp.  
Stamp**

[illegible]

## Small Fab

## Memo

0.00

0.00

WAS

## Small Fab

Deburr if necessary

[illegible]

Brake NC

NC BRAKE

## Memo

0.00

0.00

6 ~~8~~

Brake NC

1- Form using DT8751 Die as per Dwg D3315Rev: B ☐ 2- Form using

DT8179 Die and form joggle using DT8157 as per Dwg D3315□Rev: 2009/10/01

\_\_\_\_\_

QC

QC6- Inspect dimensions to drawing

## Memo

0.00

0.00

2) 502/10/61

## Quality Control

$-2$   
 $\textcircled{+6}$      $\phi$

**Work Order ID 52228**

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Page 3

Item ID: D3315-2

Accept

Revision ID: B

Item Name: Wearplate

Start Date: 9/21/2009 Start Qty: 4.00

Required Date: 10/2/2009 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160



Large Fab

Large Fab

Large Fab

Memo

Weld hard surface using D3315-2T3 as per QSI 004 and Dwg D3315 Rev:

Qty	Part Number	Description	Batch	A/R
N/A	7560 Hardcoat Rod	M109060		

0.00

0.00

0.00

0.00

0.00

0.00

EL 9-10-6 (X5)

PTO

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

2) 8/21/06

(X5) /

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

2) 8/21/06

(X5) /

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Item ID:	D3315-2	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Wearplate					
Start Date:	9/21/2009	Start Qty: 4.00		Cust Item ID:		
Required Date:	10/2/2009	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  Powdercoat Powder Coating	Grey Sandtex(Ref:4-3-5-6) per QSI005 4.3 <i>M1109091</i> Memo START TIME: <i>7:05</i> <i>3:00</i> <input type="checkbox"/> FINISH TIME: <i>7:35</i> <input type="checkbox"/> OVEN TEMPERATURE:	0.00 <i>162</i> 0.00	<i>09-10-7</i>			<i>(5)</i>			
200  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>=&gt; M 09/10/07</i>			<i>(X5)</i>	<i>0</i>		
210  Packaging Packaging	Packaging Memo Identify on inside surface using a permanent fine point marker with the following: <input type="checkbox"/> TCCA-PDA, Dart Aerospace Ltd. <input type="checkbox"/> P/N: D3315-2, B/N: BXXXXX <input type="checkbox"/> For Product Eligibility see PDA04-17 <input type="checkbox"/> and Stock <input type="checkbox"/> Location: <i>51496</i>	0.00 0.00	<i>SAD 09-10-07</i>			<i>(5)</i>			

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Item ID: D3315-2

Accept



Setup Start



Revision ID: B

Stop



Item Name: Wearplate

Start Date: 9/21/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/2/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/07

MF 09-10-07

# Picklist Print

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Page 1

Work Order ID: 52228



Parent Item: D3315-2RevB



Parent Item Name: Wearplate



Start Date: 9/21/2009

Required Date: 10/2/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010S16GA		Purchased	No			100	sf	111.6200	6.7800	10.1700		
											HB 9-9-09	
1010/1025 sheet 16GA												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111.62

105706

0.6

111410

111.02

105706

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	52228
<b>Description:</b> WEARPLATE		<b>Part Number:</b>	D3315-2
<b>Inspection Dwg:</b> D3315-2 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

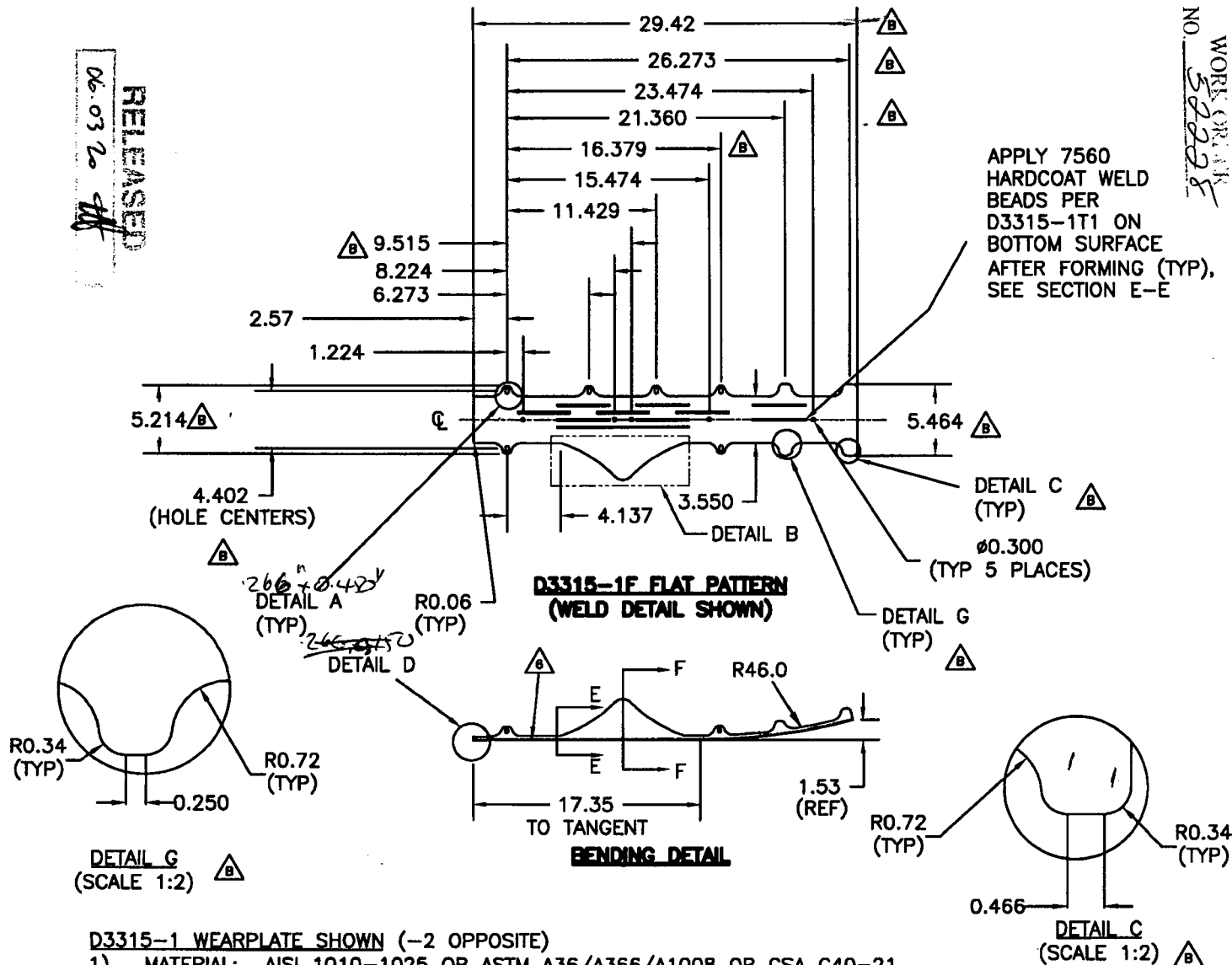
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 260 X 450	+ .006 - .001	268 X 453	*			
4.402	± .010	4.403	*			
4.137	± .010	4.138	*			
3.550	± .010	3.554	*			
5.464	± .010	5.462	x			
5.214	± .010	5.210	x			
1.224	± .010	1.226	*			
2.57	± .030	2.565	*			
6.273	± .010	6.274	*			
8.224	± .010	8.226	*			
9.515	± .010	9.513	*			
11.429	± .010	11.429	*			
15.474	± .010	15.474	*			
16.379	± .010	16.379	*			
21.360	± .010	21.360	*			
23.474	± .010	23.474	*			
26.273	± .010	26.273	*			
29.42	± .030	29.42	*			
.060	± .010	.056	*			
Ø 1.300	+ .006 - .001	1.302	*			

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-9-05	<b>Date:</b> 09/02/25	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

**DART**SHOP COPY  
RETURN TOUNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 50000

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
84	84	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 4
<i>[Signature]</i>	<i>[Signature]</i>	D3315	
DATE	TITLE	SCALE	
06.01.31	WEARPLATE	1:12	
A	04.09.10	NEW ISSUE	
B	06.01.31	UPDATE DIMENSIONS	

APPLY 7560  
HARDCOAT WELD  
BEADS PER  
D3315-1T1 ON  
BOTTOM SURFACE  
AFTER FORMING (TYP),  
SEE SECTION E-E**D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED

TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED

06.03.20

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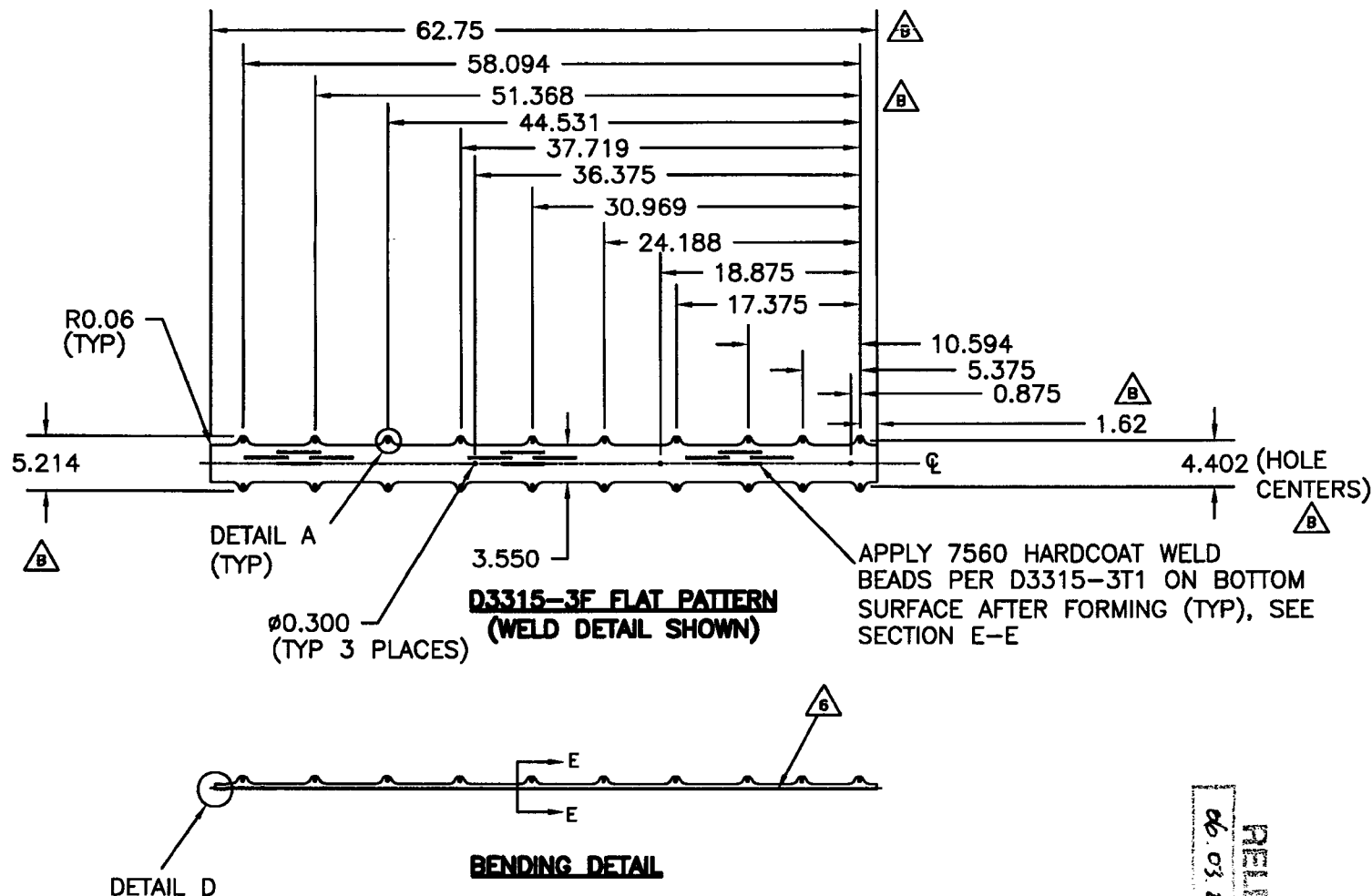
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**DART**

W/O 52225

DESIGN	DRAWN BY	DART AEROSPACE LTD
04	04	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3315
DATE	TITLE	REV. B
06.01.31	WEARPLATE	SHEET 2 OF 4
		SCALE
		1:16

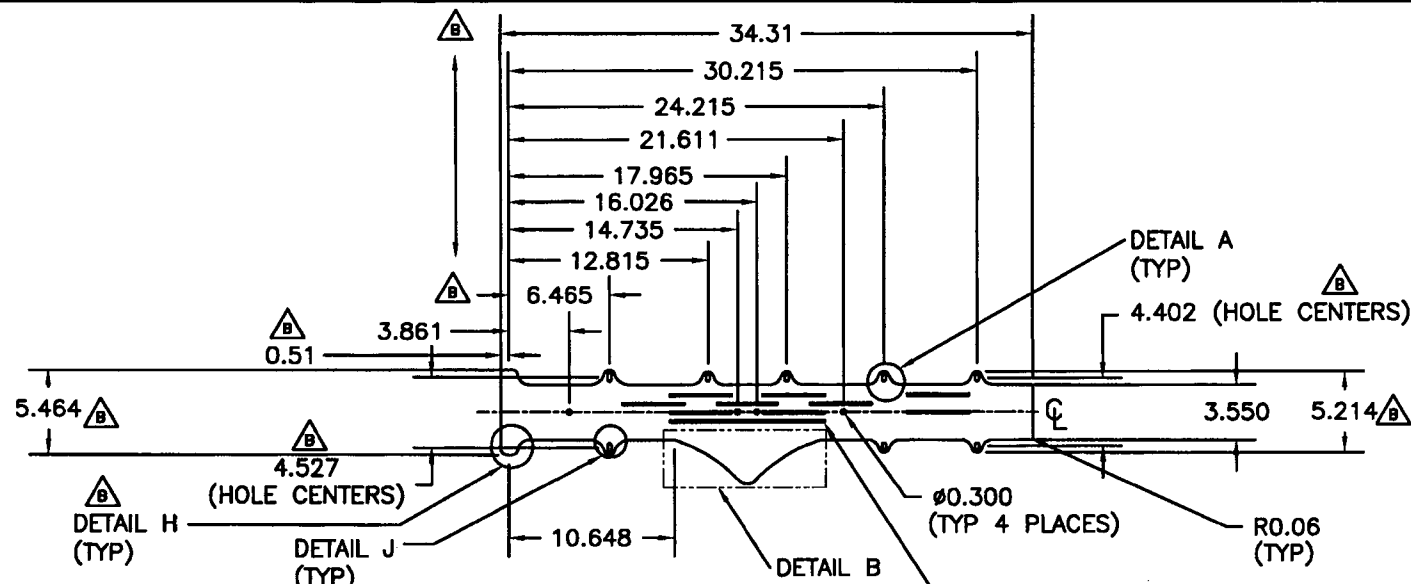
**D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

**DART**

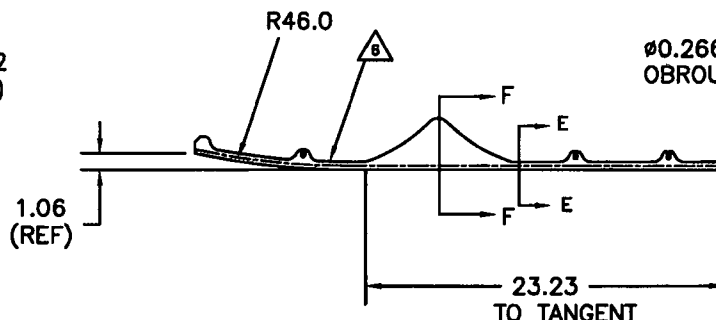
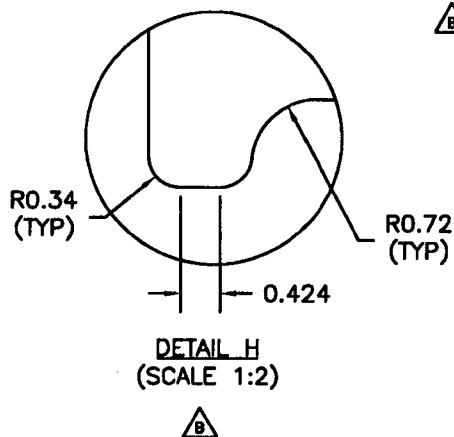
W/P 52228

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	DRAWING NO.	D3315	REV. B
TITLE	WEARPLATE	SHEET	3 OF 4	SCALE
				1:12

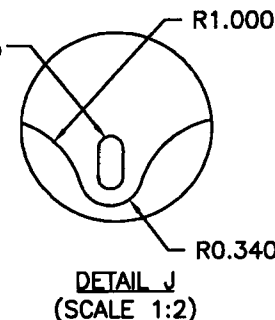


**D3315-5F FLAT PATTERN  
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD  
BEADS PER D3315-5T1 ON BOTTOM SURFACE  
AFTER FORMING (TYP), SEE SECTION E-E



**BENDING DETAIL**



**D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
  - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
  - 3) WELD PER DART QSI 004
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSION ARE IN INCHES
  - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

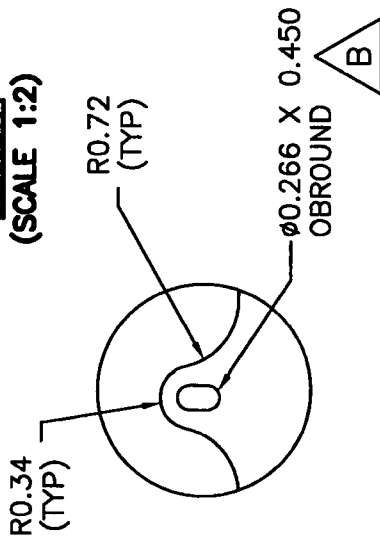
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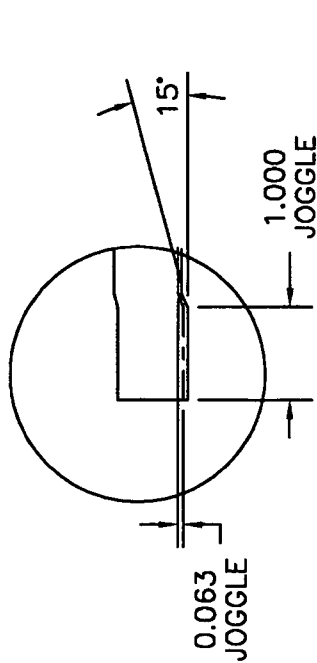
11/0 52228

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31	TITLE WEARPLATE		SCALE NTS

**DETAIL A**  
(SCALE 1:2)

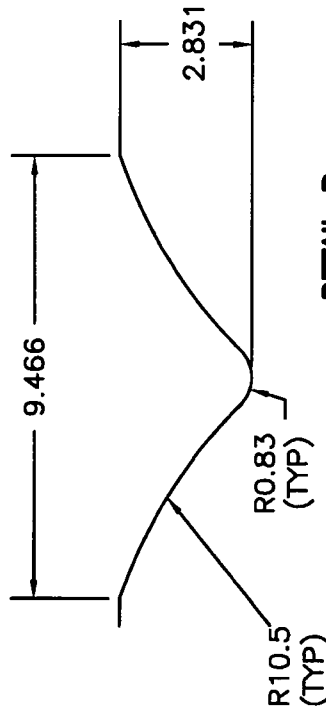


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06.03.20

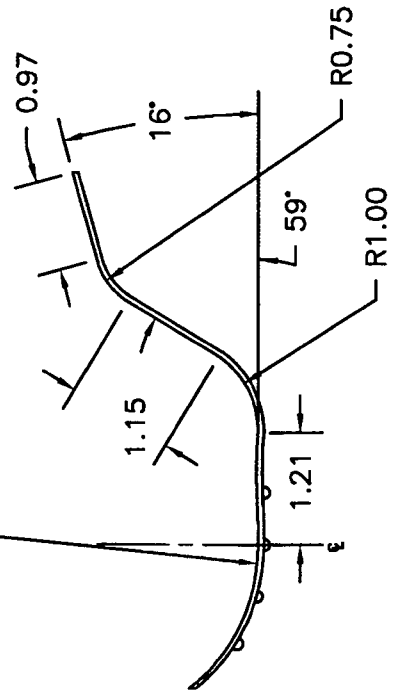


**DETAIL D**  
(SCALE 1:2)

**DETAIL B**  
(SCALE 1:4)



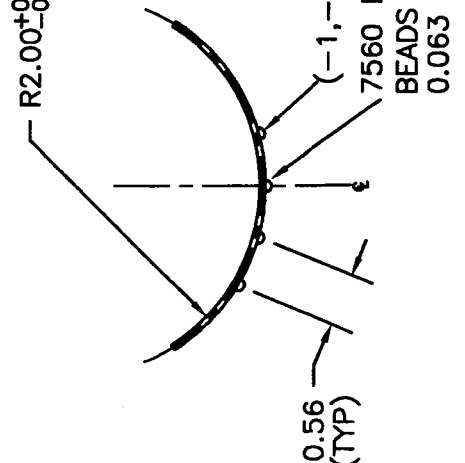
R2.00<sup>+0.030</sup><sub>-0.000</sub>



**SECTION E-E**  
(SCALE 1:2)

**SECTION E-E**  
(SCALE 1:2)

R2.00<sup>+0.030</sup><sub>-0.000</sub>



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